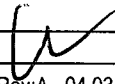
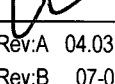


Date: Friday, 08/06/2007 2:31:22 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 31617		
Estimate Number	: 10274		
P.O. Number	: N/A	Part Number	: D350591312
This Issue	: 08/06/2007	S.O. No.	: N/A
Prsht Rev.	: NO	Drawing Number	: D3272 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32525	Drawing Revision	: B
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: 	Due Date	: 30/06/2007
Checked & Approved By	: 	Qty:	10
Comment	: Est Rev:A 04.03.22 New issue KJ/RF	Um:	Each
	: Est Rev:B 07-06-09 Added D3572-1 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



(18)

Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

RS 07.04.23

2.0	D32721	STEP
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

STEP

BATCH: 332880

PE 07.07.06

10

3.0	D30671	End Plate
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate 331653

PE 07.07.06

10

4.0	D32191	Support
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support 331343 = 12
332843 = 8

PE 07.07.06

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/06/2007 2:31:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 31617

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M102756
M104721

3-Grind End Plate flush

SE. 07-07-06 10
SE. 07-07-09 10

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1807/07/16 (10)
En 07/07/16 (10) EN

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

G.M. 07-07-16 10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE. 07-07-16 10

10.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3065-041 Step Leg Assy 331339

SE 07-07-16 10

11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3066-1 Spacer 333100

SE. 07-07-16 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/06/2007 2:31:23 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 31617

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0	MS20600AD4W4	Rivets
------	--------------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

16	MS20600AD4W4	Rivet	
----	--------------	-------	--

M104915 (170)

16.07.07.16

10

13.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
------	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

16.07.07.17

10

14.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

10 07-07-17 (10)

15.0	D30671	End Plate
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3067-1	End Plate	
---	---------	-----------	--

332 836

16.07.07.17

10

16.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
------	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M103794*

4-Grind End Plate flush

A.M 07.07.17

16.07.07.17

10

16.07.07.17

10

16.07.07.17

10

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/06/2007 2:31:23 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 31617

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-07-17 (1)

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07/07/17 (1) X10RH

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FD 07/07/18 (1)

20.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 104144 BR/M 07-07-18 (1)

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

FZ/M 07/07/18 (1)

22.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

R/S 07/07/15 (1)

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0 D22303 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

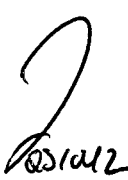
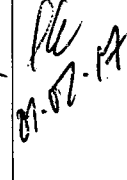
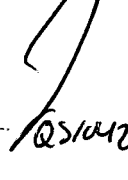
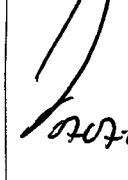
4 D2230-3 Mounting Lug

B30593 07/17/15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/17	#	found a puncture of mat- is side one step	 05/10/17	Drill a hole as necessary in the aft cap to remove foreign object. Fill hole with weld as per Q51004, and grind flush.	 07-07-17	07/07/17	 05/10/17	 07/07/17

NOTE: Date & initial all entries

Date: Friday, 08/06/2007 2:31:23 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 31617

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618

Bushing

B31831 ✓

26.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip

B32992 ✓

27.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1

Mounting Lug

B30996 ✓

28.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041

Support Assembly

B33430 ✓

29.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

M104021 ✓

30.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A

Bolt

M104746 To ✓ M104603 ✓

*

PO 7/7/19 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/06/2007 2:31:23 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 31617

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A

Bolt

M104625 ✓

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M104885 ✓

33.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M104215 ✓

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

M104156 ✓

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M103830 ✓

Pass Info

Ben Davis Accounting registered

2675/15 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/06/2007 2:31:23 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 31617

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

mw2521

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

m103830

07/19 (10)

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/19 (10)

7/7/19 (10X) SP

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location:

B

07/20 (10)

SP

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/23

Job Completion



07-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3272	REV. A SHEET 1 OF 2
DATE 04.03.01		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	

RELEASED
04.04.05 *#*

Part No.	Description	QTY -041	QTY -042
D3272-041	Step Assembly, High Long (LH)	X	
D3272-042	Step Assembly, High Long (RH)		X
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31617*

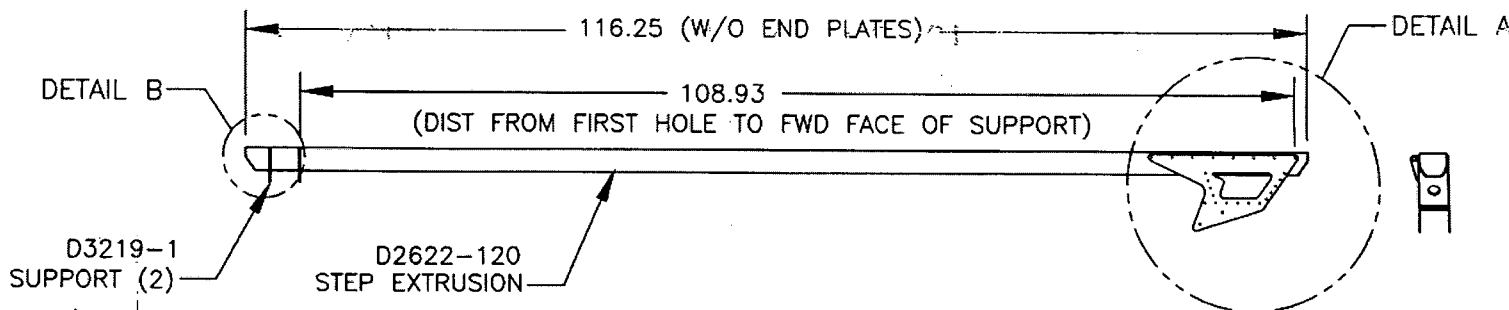
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DART



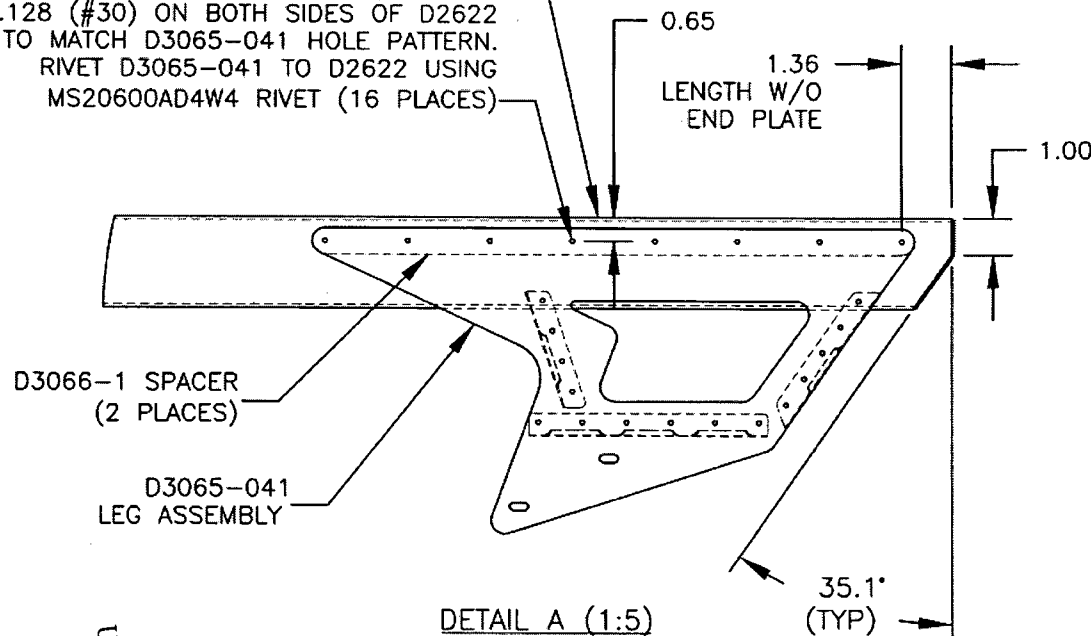
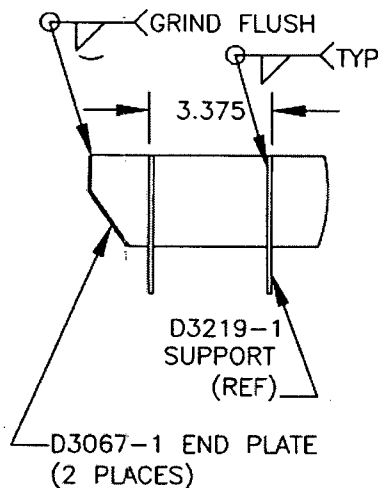
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3272	SHEET 2 OF 2
04.03.01		TITLE	SCALE
		STEP ASSEMBLY, HI LONG	1:20



1

APPLY BLACK ANTI-SKID ON
TOP SURFACE TO BOTTOM OF TOP RADIUS

DRILL $\phi 0.128$ (#30) ON BOTH SIDES OF D2622
EXTRUSION TO MATCH D3065-041 HOLE PATTERN.
RIVET D3065-041 TO D2622 USING
MS20600AD4W4 RIVET (16 PLACES)



RELEASED

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WORK ORDER
NO. 31617